

Work Order ID 81514

81514

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Thursday, March 15, 2012 8:10:47 AM

Item ID: D4150-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Attachment Arm Assembly
 Start Date: 3/15/2012 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 3/30/2012 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: ME Date: 2-03-15 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4150	B								

100 0.00
100
 Small Fab Memo 0.00
 Small Fab 1- Assemble as per dwg

Handwritten signature 12/04/11 (5)

110 0.00
110
 QC Memo 0.00
 Quality Control

Handwritten signature

(5)

120 0.00
120
 Packaging Memo 0.00
 Packaging

134

Handwritten signature

Handwritten signature

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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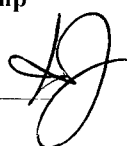
81514

Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

12/4/12 

012-041-11

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 81514

Parent Item: D4150-041

Parent Item Name: Attachment Arm Assembly

Start Date: 3/15/2012

Required Date: 3/30/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC
IPP Rev:B 10.07.22 as per revB DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C13A Bolt		Purchased	No			100	Each	61.0000	2	12		3/12/04/11	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST351		61							
				117366		11							
				120630		50							
D4150-1 Arm		Manufactured	No			100	Each	1.0000	1	6		3/12/04/11	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST133		1							
				76301		1							
D4150-3 Arm Plate		Manufactured	No			100	Each	4.0000	2	12		3/12/04/11	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST133		4							
				80739		4							
MS21043-3 Nut		Purchased	No			100	Each	836.0000	2	12		3/12/04/11	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG		72							
				103691		72							
				GA		334							
				120693		334							
				ST301		430							
				118077		2							
				118614		378							
				118686		30							
				119758		20							

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Picklist Print

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Work Order ID: 81514

Parent Item: D4150-041

Parent Item Name: Attachment Arm Assembly

Start Date: 3/15/2012

Required Date: 3/30/2012

Start Qty: 6.00

Required Qty: 6.00

NAS1149C0332R

Purchased

No

100

Each

3,597.0000

4

24

Washer

Location

Loc Qty

Loc Code

ST297

3597

118354

551

119736

196

120648

2850

1121255
(200)

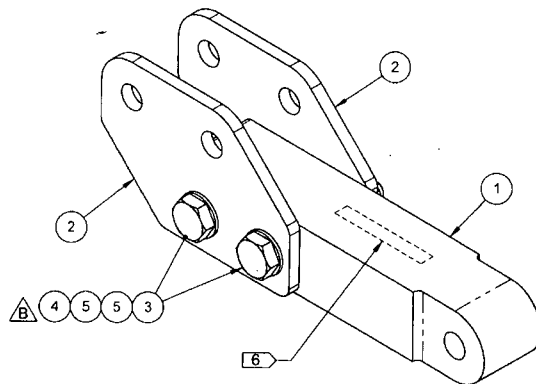
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D4150-041 ATTACHMENT ARM ASSY

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4150-041	ATTACHMENT ARM ASSY
1	1	D4150-1	ARM
2	2	D4150-3	ARM PLATE
3	1	AN3C13A	BOLT
4	1	MS21043-3	NUT
5	2	NAS1149C0332R	WASHER

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4150-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.82 lbs

#81514

RELEASED
2010-07-16

B	REPLACED QTY(3) MS20615-4M20 WITH QTY(2) EACH AN3C13A, MS21043-3 AND QTY(4) NAS1149C0332R WASHER (ZN D3-1); Ø0.191 2 PL REPLACES Ø0.129 3 PL (ZN C6-2, C7-2, B4-3 & B5-3) REASON: SEE TR-D350-607-2 REV. B.	MB	10.07.08
A	NEW ISSUE	MB	10.06.18
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.07.08		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4150** REV. B
SHEET 1 OF 3
TITLE **ATTACHMENT ARM ASSY** SCALE NTS

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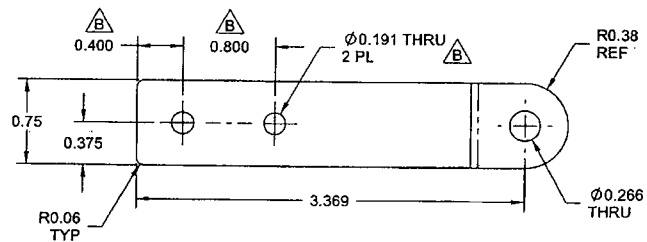
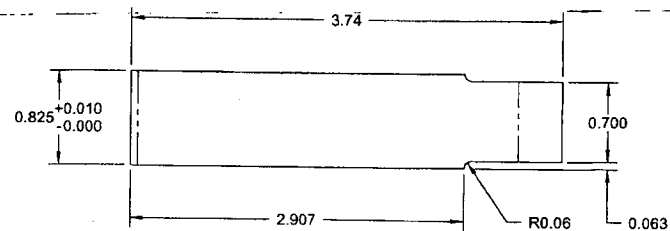
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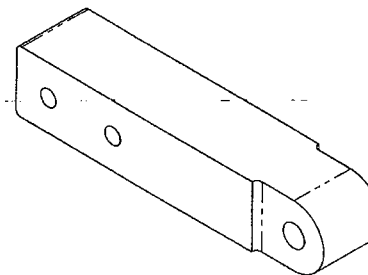
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NOTE: Date & initial all entries



D4150-1 ARM



81514
RELEASED
 2010-07-16
 MP

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276
 REF DART SPEC M304B OR M303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.60 lbs

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MFG. APPR.		D4150	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		ATTACHMENT ARM ASSY	NTS
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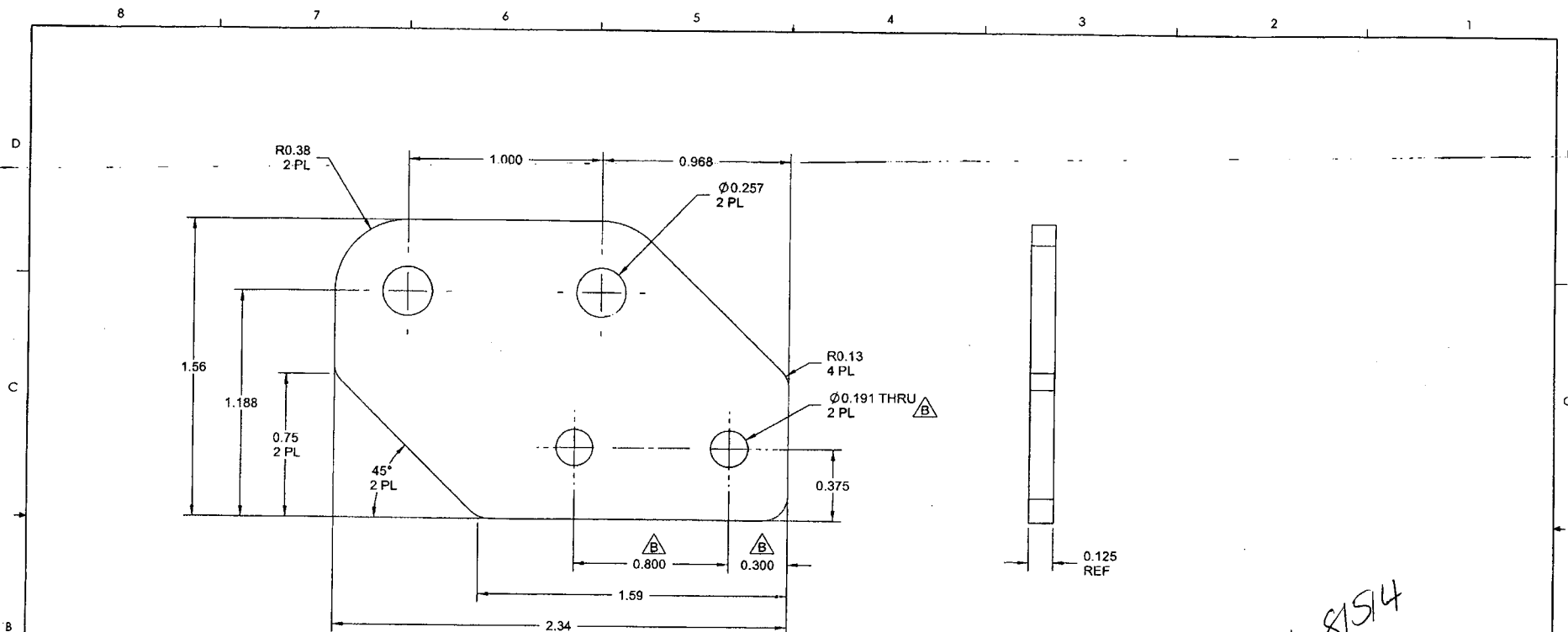
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D4150-3 ARM PLATE

81514

RELEASED
2010-07-16

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" THICK SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.10 lbs

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MFG. APPR.		D4150	SHEET 3 OF 3
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